

Work Order ID 57350

April 6, 2010 8:20:29 AM



Page 1

Item ID: D3591-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 06/04/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: 10-4-04 Date: 10/04/13

Tooling:

Date:

Run Start



QC: Date:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3591	Rev B								
100	Hard: 5SE CONVENTIONAL LATHE	0.00							
Lathe Conv	Memo	0.00							
Conventional Lathe	1-Turn as per dwg D3591 2-Deburr								
			SL	10/04/13					(60)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control			SL	10/04/13					
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control			SL	10/04/14					(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

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Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 72

0.00

Memo

0.00

Birdley

10-4-15 60x SL

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/4/19 *JF*

mk
10-4-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:20:33 AM

Page 1

Work Order ID: 57350

Parent Item: D3591-1

Parent Item Name: Bushing

Comments: IPP A 07.02.01 new issue EC
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Start Date: 06/04/2010

Required Date: 09/04/2010

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	29.6240	22.1053			
304 RD Tube .500 x .035W												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT017	29.624
112187	4.75
112800	24.874

114356

22.3

SL 10/04/14

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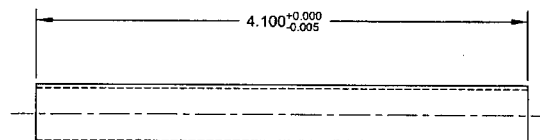
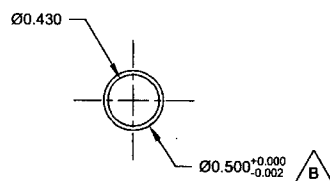
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D3591-1 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57350

BS 10-46

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TR0.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
08-09-03/11

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)		AJS	08.08.25
A	NEW ISSUE		PH	07.01.16
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3591	SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	BUSHING	NTS	
DATE		08.08.25		
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